

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006120**Date Inspected:** 28-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Wuzhi Cheng and Chen Likun			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower and OBG		

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBW3

ZPMC's qualified welding personnel's identified are Mr. Lu Yangyuan (202841) and Mr. Xin Meng (053742) perform FCAW welding on weld joint identified as OBW3-004 and 002. ZPMC QC identified Mr. Wuzhi Cheng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2233-B-U2-F.

ZPMC's qualified welding personnel identified is Mr. Dai Lu (048659) perform SMAW welding on weld joint identified as OBW3-001. ZPMC QC identified Mr. Wuzhi Cheng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM.

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### Bay 10

ZPMC's qualified welding personnel's are identified as Mr. Jiang Jinlong (040239), Mr. Zhang Jinlong (057220) and Mr. Fan Chunlei (040491) perform SMAW welding on weld joint identified as NSD1-A128B/H-113B, 3B and NSD1-A166E/J-52B, 32A. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-C-U2.

ZPMC's qualified welding personnel's are identified as Mr. Jian Zhou (040261), Mr. Tao Qian (00457) Mr. Li Haishan (048784), Mr. Zhang Yiqui (048027) and Zhu Zhongyum (057194) perform FCAW welding on weld joint identified as SSD1-TL5-B/L-1A and SSD1-FASA3-1E/E-26, 27, 58 and 59. ZPMC QC identified Mr. Li Peng Fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F-1.

### Bay 11

ZPMC's welding personnel's are identified as Mrs. Wu Aixiang (044560) and Mrs. Li Xiaoqing (040772) performing groove welding of weld joint ESD1-FCSA3-2B/C-65B and ESD1-FCSA3-2B/C-66B. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Ming and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-1.

ZPMC's qualified welding personnel's are identified as Mr. Yang Zhaoyan (047470), Mr. Xie Zhongcheng (058772), Mr. Yan Zaihua (040669) and Mr. Yin Guoqiang (058772) perform FCAW welding on weld joint identified as ND1-A468-18M-1-1A, 6A, 28B, NDI-A476-53M-1-3A, 29A, 14B and ESD1-TLB/L-4A/B. ZPMC's QC identified Mr. Yu Dong Ping and Mr. Li Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-TC-U5b-1, WPS-B-T-2212-TC-U5b-1 and WPS-345-FCAW-1G (1F)-Repair.

### Bay 5

This QA Inspector observed ZPMC welder Mao Shuai (217294) welding in the 4G position on weld joint CB201G-148/166 in OBG Assembly Shop (Bay 5). Noted welder is qualified in the 3G position. QA Inspector issued an incident report on this date for the welding observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz, Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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